

Date: Thursday, 27/11/2008 2:23:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 43807	
Estimate Number : 10315	
P.O. Number :	Part Number : D265635
This Issue : 27/11/2008 S.O. No. :	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : D
Previous Run : 35494	Material :
Written By :	Due Date : 10/12/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 08.11.27</u>	
Comment : Est: D 02.10.25 Re-format KJ/RF Est Rev:E Now on Waterjet 06-08-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
-----	------------	-----------------



Comment: Qty.: 0.3750 sf(s)/Unit Total : 4.5000 sf(s)

1010/1025/A21/6aA SHEET

20 GAUGE .040" THK

Batch: 109289 HB 8-12-10

(13)

2.0	WATER JET	FLOW WATER JET
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 $\frac{D}{D}$

HB 8-12-10

**Comment:** FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-12-10

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 08/12/11

(13)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

1-Deburr if necessary

HB 8-12-10

2-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.

3-Identify as D2656-35.

S 08/12/11

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: WEARPLATE

Job Number: 43807

Part Number: D265635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

505/12/11 (413)

7.0

POWDER COATING

POWDER COATING



M 109 648



(13x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:10
320 OF
11:40

M-1 08/12/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08-12-12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(13x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F P 20

M-1 08/12/12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.12.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

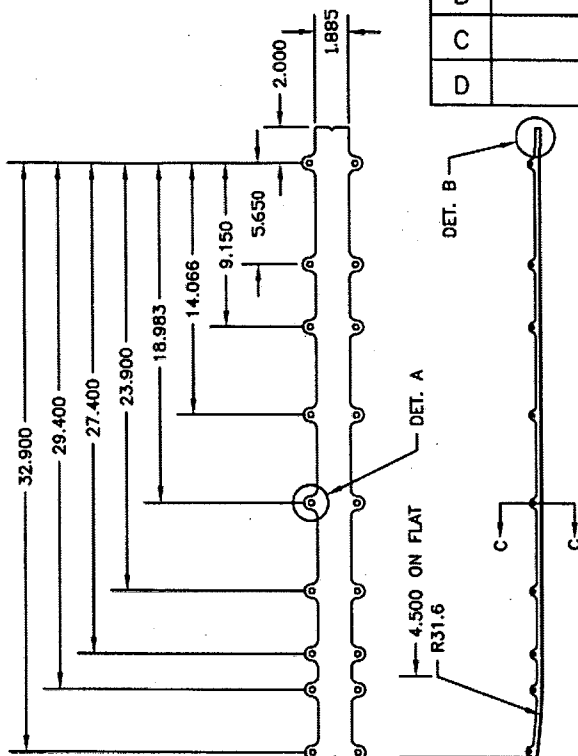
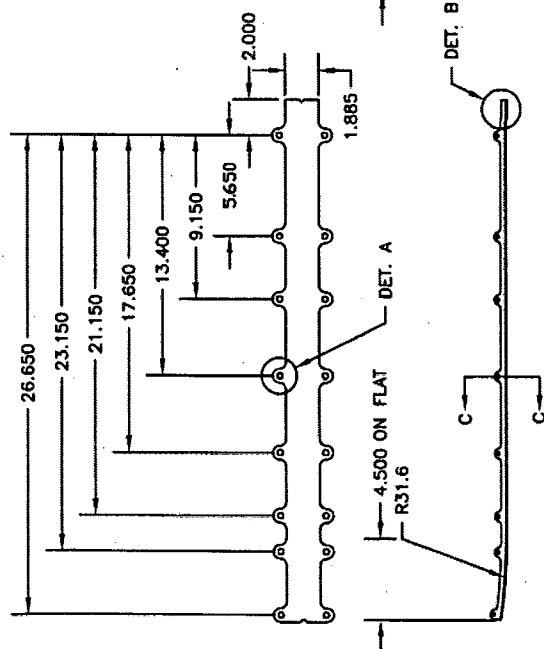
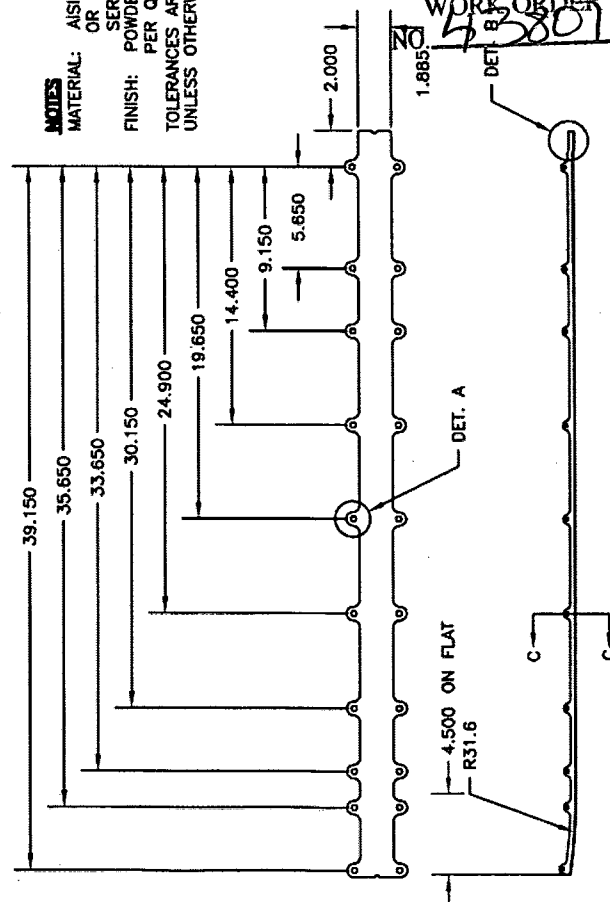
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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

D2656-13**D2656-11****D2656-15**

NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

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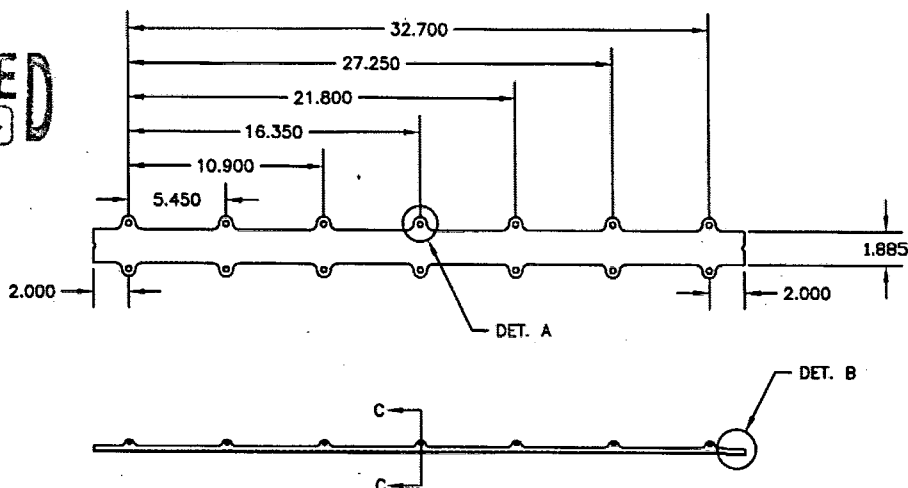
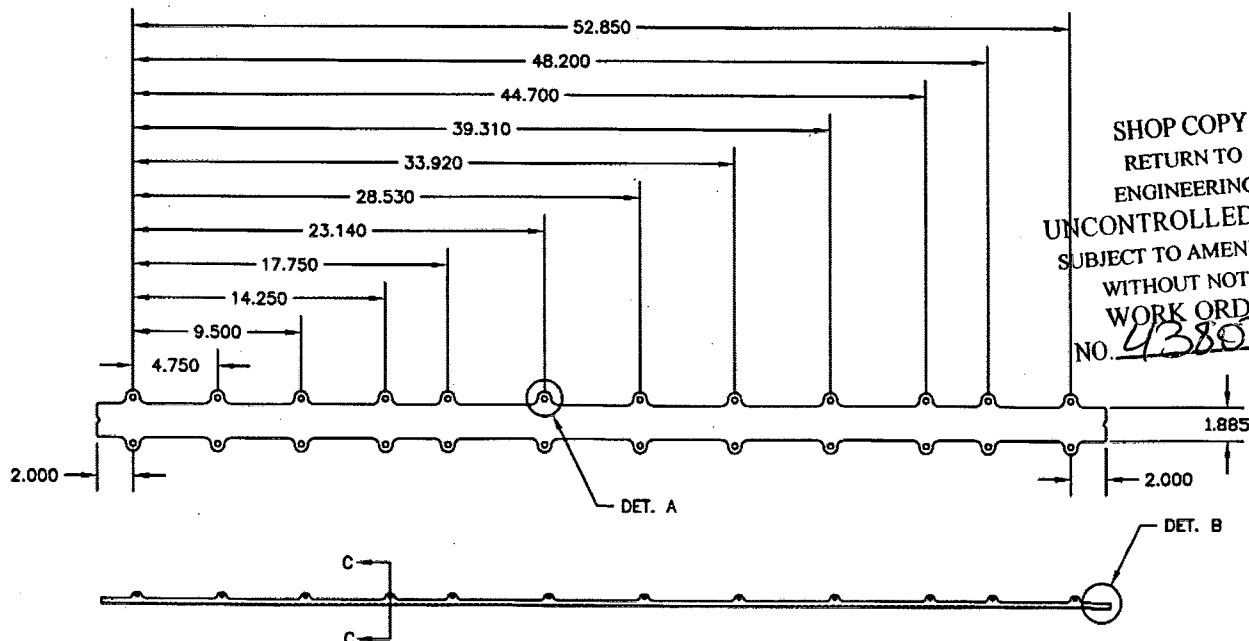
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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05.01.06 *[Signature]***D2656-21****D2656-23**

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NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

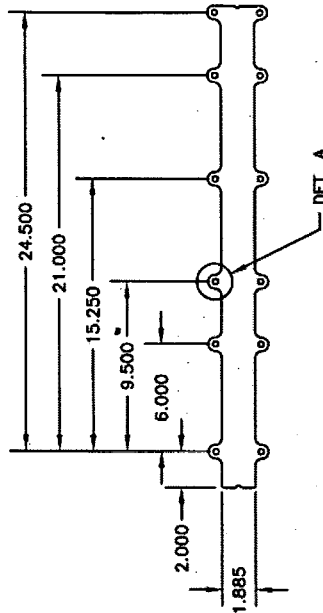
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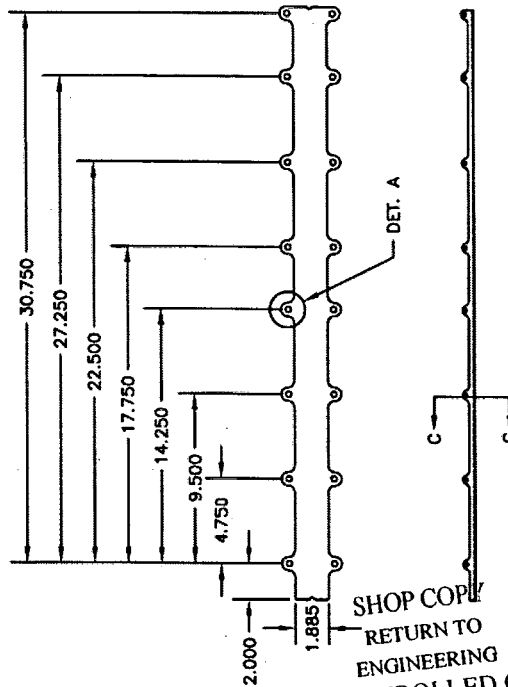


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33



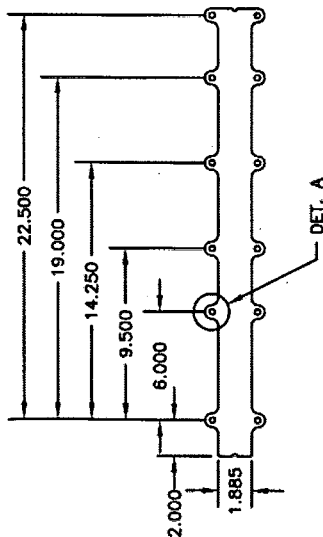
D2656-37



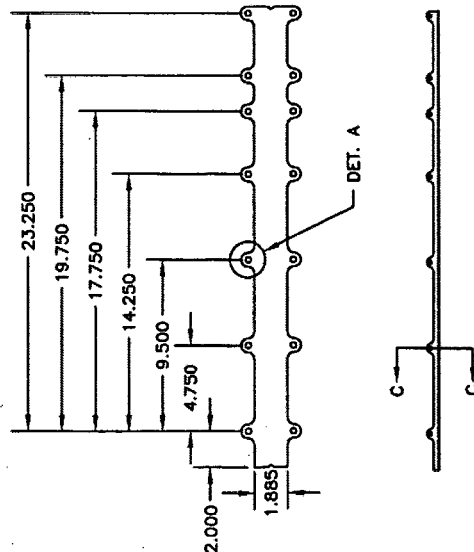
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D2656-31



D2656-35



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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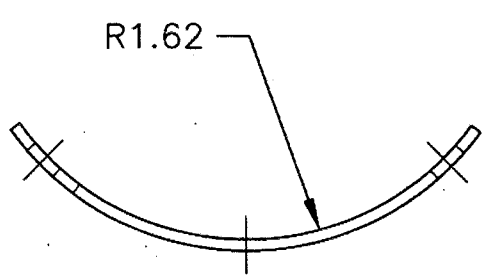
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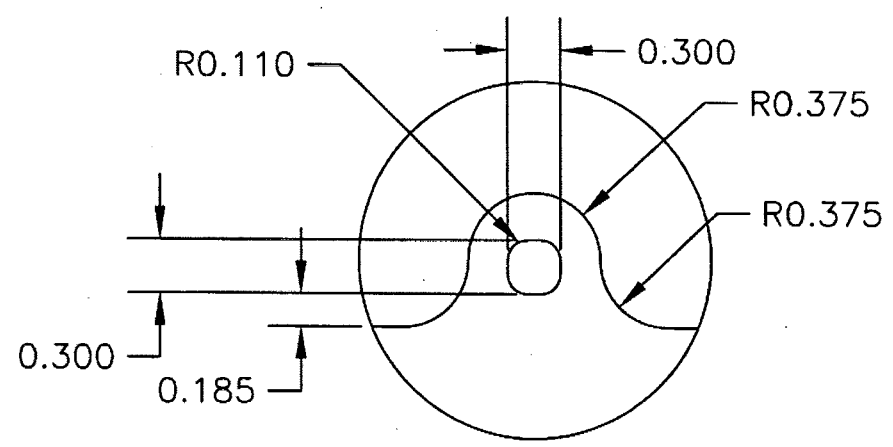
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

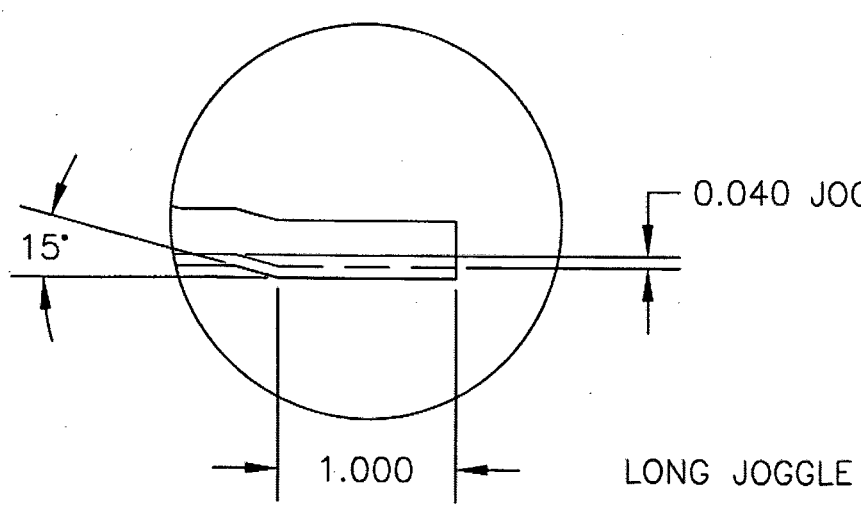


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DETAIL A



DETAIL B



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